

Date: Thursday, 07/02/2008 2:57:24 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP BRACKET
Job Number : 37299
Estimate Number : 13160
P.O. Number :
This Issue : 07/02/2008 S.O. No. :
Prsht Rev. : NC Part Number : D37281
First Issue : / / Type : SMALL / MED FAB Drawing Number : D3728 U/R
Previous Run :
Written By : Material :
Checked & Approved By : Due Date : 08/02/2008 Qty: 20 Um: Each
Comment : Est Rev:A 08-01-30 new issue DD verified by:EC



Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0250X06000 6061-T6 Bar .25" x 6.0"



Comment: Qty.: 1.3484 f(s)/Unit Total: 26.9682 f(s)

6061T6 aluminium bar 6.00" X .250" thick

(M6061T6B0250X06000)

Batch: 100782 IB 8-28

100782 x3
103433

2.0 WATER JET 782 FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3728

Dwg Rev: 4/2 IB 8-2-8

Prog Rev: 4/2
2- Deburr if necessary IB 8-2-8

(21)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

500/2/00 (21)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr if necessary

SAD 08:02:08

(21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 07/02/2008 2:57:24 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP BRACKET

Job Number: 37299

Part Number: D37281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL



(20) PTO

Comment: INSPECT WORK TO CURRENT STEP

08.02.11 (20)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08.02.12
FF 08-02-12 (20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 08-02-12 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: NA

08.02.12 (20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

08.02.12

Job Completion



08.02.12 (20)

POSITIVE RECALL

EFFECTIVE 08.02.07 AUTH 4

RELEASED 08.02.11 DATE 12

SCANNED
BY 14
W/O 37581

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/02/11	6.0	Use one to make drill jig	AA	08/02/11			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7

Prog done
Est done

2 1

RELIMINARY ISSUE

SS 08.02.05

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM
PER AMS-QQ-A-250/11 OR AMS 402
(REF DART SPEC M6061T6S.250)
OR: 6061-T6 (OR 6061-T651/T6510/T6511)
PER AMS-QQ-A-225/8 (OR AMS 411)
PER AMS-QQ-A-200/8 (OR AMS 416)
(REF DART SPEC M6061T6B)

- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OT
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.93 lbs

	AJS	08.02.04
DESCRIPTION	BY	DATE
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWING NO.	REV. A	
D3728	SHEET 1 OF 2	
TITLE	SCALE	
STEP BRACKET	NTS	
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DART AEROSPACE LTD		Work Order: 37299
Description: STEP BRACKET		Part Number: D3728-1
Inspection Dwg: D3728-1 Rev: U/R		Page 1 of 1

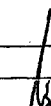
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .159	+ .005 - .001	.162	*			
Ø .191	+ .005 - .001	.192	*			
4.25	+/- .030	4.255	*			
2.500	+/- .010	2.491	*			
.88	+/- .030	.883	*			
.450	+/- .010	.450	*			
.608	+/- .010	.608	*			
.625	+/- .010	.625	*			
1.250	+/- .010	1.249	*			
1.40	+/- .030	1.408	*			
1.00	+/- .030	1.011	*			
1.00	+/- .030	1.016	*			
1.00	+/- .030	1.012	*			
2.75	+/- .030	2.75	*			
10.212	+/- .010	10.212	*			
15.038	+/- .010	15.038	*			
15.41	+/- .030	15.41	*			
6.070	+/- .010	6.070	*			
2.370	+/- .010	2.370	*			
6.051	+/- .010	6.051	*			
.651	+/- .010	.651	*			

Measured by: 13
Date: 8-28

Audited by: 
Date: 06/01/09

Prototype Approval: 
Date: 08.02.11

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	